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D3286-1

Job Sheet 215026

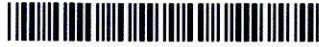


Part No: D3286-1

Job Qty: 20 pcs

DAS
21
9-88

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/4/20

Job Tracking No:

Due Date: 11/20/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 04.07.14 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-06-16 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		11/19/20	0.17	0.78	Waterjet - Flow		on 20/11/18
120	QC 8	20 pcs		11/19/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
QC 8 - 23									
QC 8 - 57									
QC 8 - 76									
QC 8 - 61									
QC 8 - 66									
QC 8 - 73									
							Plex 11/4/20 2:04 PM Dart.lajeunesse.marie		

DAS
40
9-88
NOV 18 2020

130	Small Fab - Brake NC - B4B	20 pcs	11/20/20	0.25 0.35	QC 8 - 82	
					Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
140	QC 5	20 pcs	11/20/20	0.00 0.00	Small Fab - Brake - 3 - B4B	NOV 23 2020
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	NOV 24 2020
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
150	Packaging 3-1 - Stock - B4B	20 pcs	11/20/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
160 QC 21 - SA	20 pcs	11/20/20	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89
				QC 21 - SA - 70	NOV 24 2020
				QC 21 - SA - 9	
				QC 21 - SA - 77	
				QC 21 - SA - 28	

Part Op 100 - (Waterjet - Flow)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Form as per dwg)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	1.4980 sf (.0749 ea)	100-Waterjet - Flow - 1	S242860

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	1	72	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	5.374inches ± 0.010	5.384 5.364		
2	Doubler	3.974inches ± 0.010	3.984 3.964		
3	Doubler	2.000inches ± 0.010	2.010 1.990		
4	Doubler	1.000inches ± 0.010	1.010 0.990		
5	Doubler	0.700inches ± 0.010	0.710 0.690		
6	Doubler	0.188inches + 0.005 - 0.001	0.193 0.187		
7	Doubler	0.125inches ± 0.010	0.135 0.115		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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AEROSPACE

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Container No: S313884



Part: D3286-1

Job No: 215026

Serial No/Batch: S313884

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/18/20